

Date: Thursday, 04/09/2008 1:23:00 PM
User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206 EXTRUSION BENDING
Job Number :	41820		
Estimate Number :	10311		
P.O. Number :		Part Number :	D2620
This Issue :	04/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2620 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	40451	Drawing Revision :	B
	Type :	Material :	
	SKIDTUBES	Due Date :	30/09/2008
Written By :		Qty:	20
Checked & Approved By :	<u>JLD 08.9.04</u>	Um:	Each
Comment :	Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001160	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	34715

8-08-09-07

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
and Folio Ft008
2- Cut Fwd end of tube as per Dwg D2620

8-08-09-08

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

DP 8-9-8

(20)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: Skid tube

DP 8-9-8

(20)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

08/09/09

Job Completion



MF 08-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

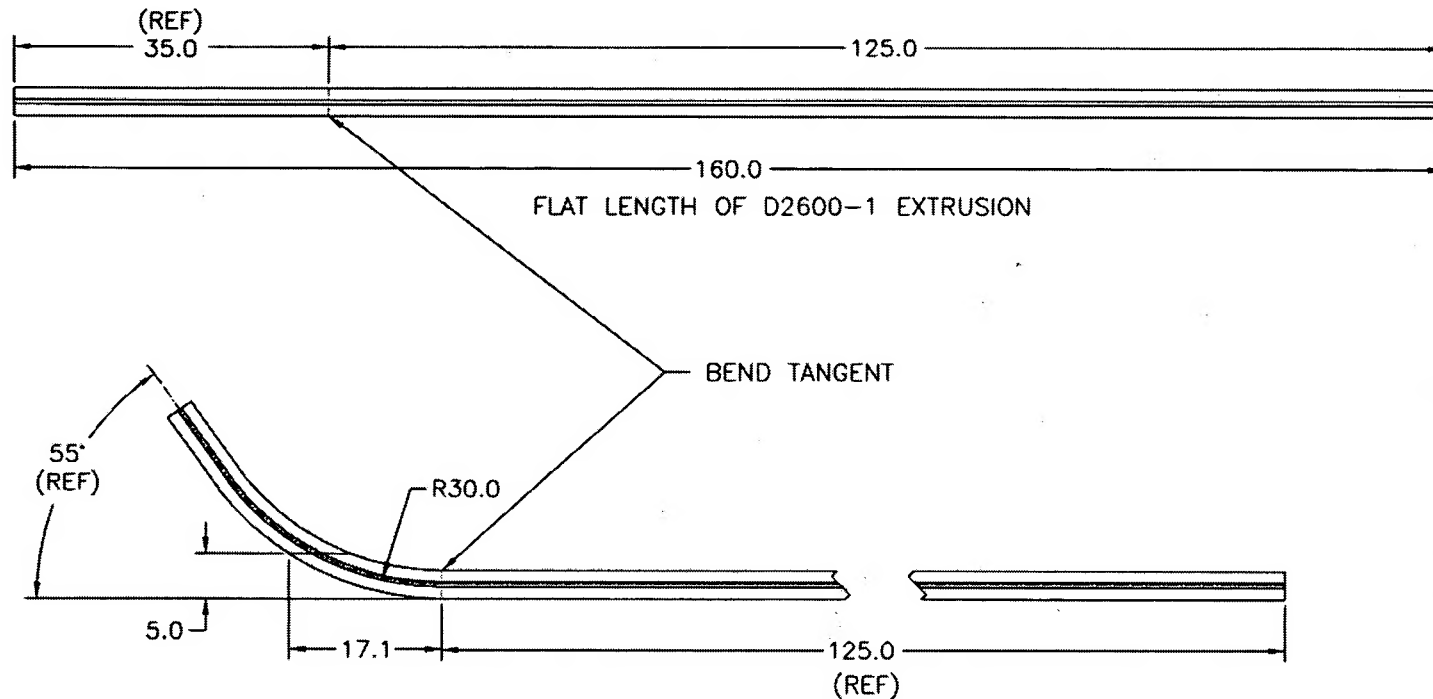
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
99.09.10	206 SKIDTUBE BENDING CONTROL	SHEET 1 OF 1
A	97.11.07	SCALE
B	97.09.10	1:20
	NEW ISSUE	
	UPDATE FOR IN-HOUSE BENDING	

RELEASED
44.04.15 DS

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
44-04-15
NO. 44000